



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

RBW109-3501-08-115

Job Sheet 190642



Part No: RBW109-3501-08-115

Job Qty: 3 pcs

Part Name: Adapter, Landing Gear Shockstruts Nitrogen Change



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/12/19

Job Tracking No: SIOP

Due Date: 3/12/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW109-3501-08-115 Rev 3 IPP Rev A 18.02.14 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		3/12/19	0.00	0.00	Purchasing - 1		DP FEB 21 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	3 pcs		3/12/19	0.00	0.00	Packaging 2 - 1 - B4B		DP FEB 21 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S155405



Part: RBW109-3501-08-115

Job No: 190642

Serial No/Batch: S155405

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 02/21/19

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	3 pcs	3/12/19	0.00 0.00	QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
130	Packaging 3-1 - Stock - B4B	3 pcs	3/12/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	3 pcs	3/12/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS
FEB 21 2019 68
9-89

DAS
28
9-89

FEB 25 2019

DAS
21
9-89

Part Op 100 - (Purchasing) Issue P/O: 042619 - MANUFACTURE RBW109-3501-08-115 AS PER DWG Supplier: METEC
 Descriptions: ***NOTE*** Ensure solder joint is clean of all debris. Soldered joint must hold 1500psi of nitrogen charge. Certificate of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

x3 RLM

14 Feb 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW109-3501-08-115P	Adapter, Landing Gear Shockstruts Nitrogen Change	3 Ea (1 ea)	100-Purchasing	5155384

Job Allocations

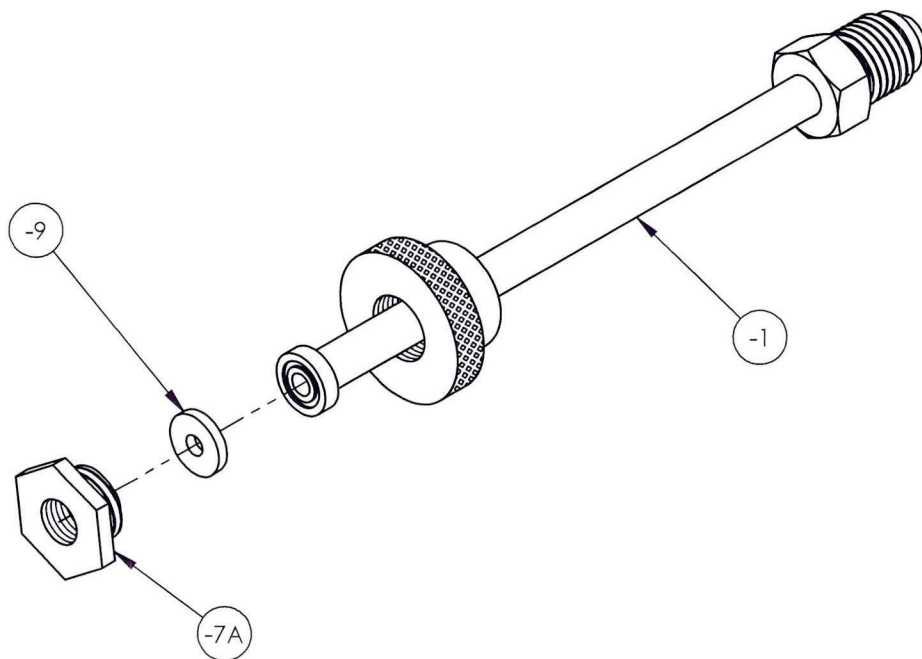
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW109-3501-08-115P	3	0	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		MERGED -7, -8 & -9 INTO -7 AS BUYOUT. DELETED PAGE 4. -5 CH'D TUBE DIMENSIONS, WAS $\varnothing .180/\varnothing .250$, IS $\varnothing .210/\varnothing .280$.	9/14/2010	WP	DW
2		-5 CH'D MATERIAL FROM BRASS TO 303/304, ADDED EXTRA GASKET RELIEF. MERGED -7, -9, AND -11 INTO -7 ASSEMBLY.	9/20/2010	WP	DW
A2		CORRECTED P/N WAS RBW109-351-08-115 IS RBW109-3501-08-115. -5 CH'D ID FROM $\varnothing .115$ TO $\varnothing .156$.	6/26/2012	JAG	SE
2A		UPDATED SHEET FORMATS AND DRAFTING STANDARDS. SEPARATED -3 & -5 TO INDIVIDUAL SHTS. ADDED -7A TO BOM.	10/16/2013	CFS	RW
3	16-0208	-3 CH'D DIM WAS $\varnothing .24 \pm .001$ IS $\varnothing .242 \pm .001$. -5 CH'D DIM'S WAS $\varnothing .156$ IS $\varnothing .135 \pm .030$, WAS $\varnothing .240$ (S.F. -3) IS $\varnothing .240 + .000/- .002$ (S.F. -3), WAS $\varnothing .375$ IS $\varnothing .38$. DELETED NOTE 1 SHEET 1.	11/2/2016	RJC	JAG



DART AEROSPACE																									
TITLE ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE																									
DWG NO. RBW109-3501-08-115	REV 3																								
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX $\pm$.005 FRACTIONS $\pm$ 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX $\pm$.01 ANGLES $\pm$ 5°</td> </tr> <tr> <td></td> <td>.X $\pm$.1 SURFACES = 125/</td> </tr> <tr> <td>DRAWN BY: PERRITT</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>AGUSTA AW139</td> </tr> <tr> <td>SCALE 1:1</td> <td>DATE 4/23/2010</td> </tr> <tr> <td colspan="2">SHEET 1 OF 4</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8	SPEC	.XX $\pm$.01 ANGLES $\pm$ 5°		.X $\pm$.1 SURFACES = 125/	DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR: LINDSAY	USED ON MODEL	APPROVED: GILBERT	AGUSTA AW139	SCALE 1:1	DATE 4/23/2010	SHEET 1 OF 4	
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SHEET 1 OF 4																									

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	SOLDER ASSY.			2
	1		-3		FLARED FITTING, 37°	316 S.S.	7/16-20 FOR 1/4 OD TUBE (MCMaster-CARR #50715K522) MODIFIED	3
	1		-5		TUBE	304 S.S.		4
	1		-7		FITTING, THUMB NUT		(AIRCRAFT SPRUCE #06-11700 SCHRADER #6116) MODIFIED	2
			-7A	1	FITTING, HEX NUT		PART OF -7	1
		B/O	-9	1	GASKET	HARD FIBER	(AIRCRAFT SPRUCE #SK2043-5)	1
	ASSY -1							



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042619



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO042619
PO Date: 2/14/19
Due Date: 2/19/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190642	RBW109-3501-08-115P			Adapter, Landing Gear Shockstruts Nitrogen Change As Per Dwg RBW109-3501-08-115 Rev. 3	Firmed	-	2/19/19	3 Ea	0 Ea	3 Ea	\$498.00/Ea	\$1,494.00
Grand Total:													\$1,494.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 2/14/19 3:48 PM dart.Lussier.Patrick

1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART AEROSPACE		DATE: Feb. 19, 2019	
		P.O.# 42619	
		WEJAY JOB# 39435	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
Adapter, landing gear, shockstruts,	3	Fabricate complete as per drawing	RBW109-3501-08-115
Nitrogen charge		specifications	Rev.3, sheets 1-4
RBW109-3501-08-115P			
Job: 190642			
Material used: Drawing RBW109-3501-08-115-5: Wejay TN#34007-1 Drawing RBW109-3501-08-115-1, item -7: Wejay TN#34427-2 Drawing RBW109-3501-08-115, item -9: Wejay TN#34427-1 Drawing RBW109-3501-08-115-3: Wejay TN#34428-1			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,



Edward Jansen
Authorized Q.A. Signatory